

Date: Thursday, 28/05/2009 9:11:26 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	MOUNTING LUG
<b>Job Number</b> :	48229		
<b>Estimate Number</b> :	10255		
<b>P.O. Number</b> :		<b>Part Number</b> :	D22301
<b>This Issue</b> :	28/05/2009	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2230 REV F
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	47912	<b>Drawing Revision</b> :	F
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	<u>JULIA DAWSON</u>	<b>Due Date</b> :	04/06/2009
<b>Comment</b> :	Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC		
		<b>Qty:</b>	200
		<b>Um:</b>	Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D2423	Lug Extrusion
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+ 12" deep.



**Comment:** Qty.: 0.0717 f(s)/Unit Total: 14.3430 f(s)

Lug Extrusion D2423 Extrusion

Batch: B43722

Amk

SP 09/06/05 200

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW

Cut D2423 extrusion to 0.82"

Batch: B43722

Amk

SP 09/06/05 (200)

3.0	D22301P	LUG
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 200.0000 Each(s)

LUG

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

1-Machine per folio D2230-1

(Check for crack while loading into the machine.)

2-Tumble and deburr rough edges after tumbling

SP 09/06/13

(200)

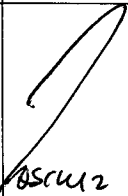

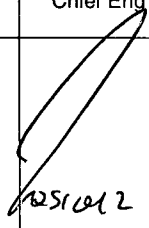
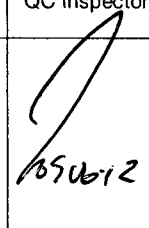
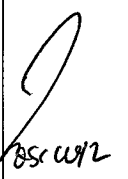

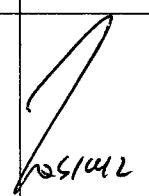
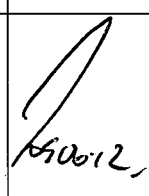
SP 09/06/13

mmf 09/06/07

SP 09/06/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2230-1 PAR #: N/A Fault Category: Machining NCR: Yes No DQA: 1 Date: 09.06.24  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 1 Date: 09.07.15

NCR: <u>48229</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/06/07	4.0	3 parts were Scrap during 2 <sup>nd</sup> operation. Pull up during any varying. PROCESS: program. 1 part was too thick & tilted during facing.		Scrap 4 parts. & replace B 43722 ↕	mm 09/06/07			
09/06/11	4.0	2 part Scrap during 2 <sup>nd</sup> op.  <u>Total 6</u>		<del>Scrap</del> Scrap & replace 2 B 43722	DJP 09/06/12			

NOTE: Date & initial all entries

Date: Thursday, 28/05/2009 9:11:26 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 48229

Part Number: D22301

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmf 09/06/07

09/06/13

(200)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L

09/06/14

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

umo

09/06/15

(x200)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-06-15

(x200)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

START TIME: 10:55am

OVEN TEMPERATURE: 320°C

FINISH TIME: 11:25am

HP

09-06-16

(x200)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL

09/06/16

(200)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

9/6/16

(200)

SD

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/18

Job Completion



U 09.06.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

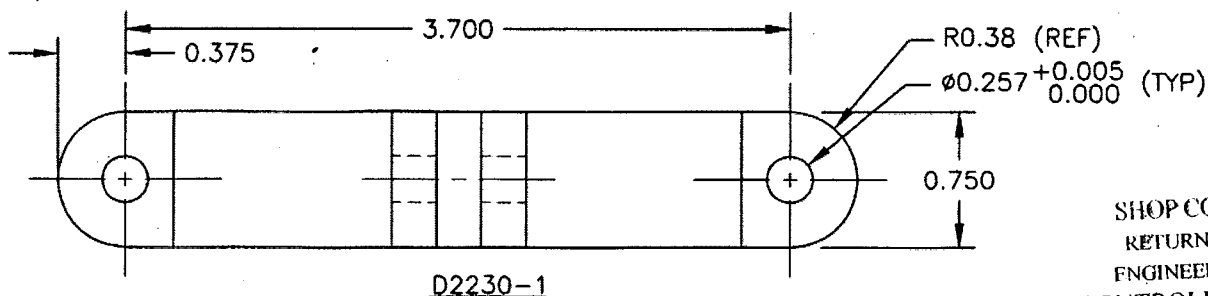
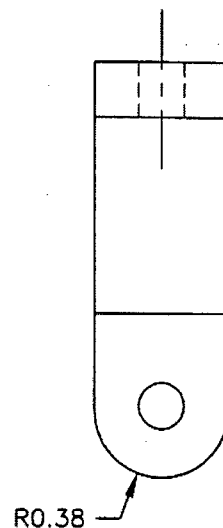
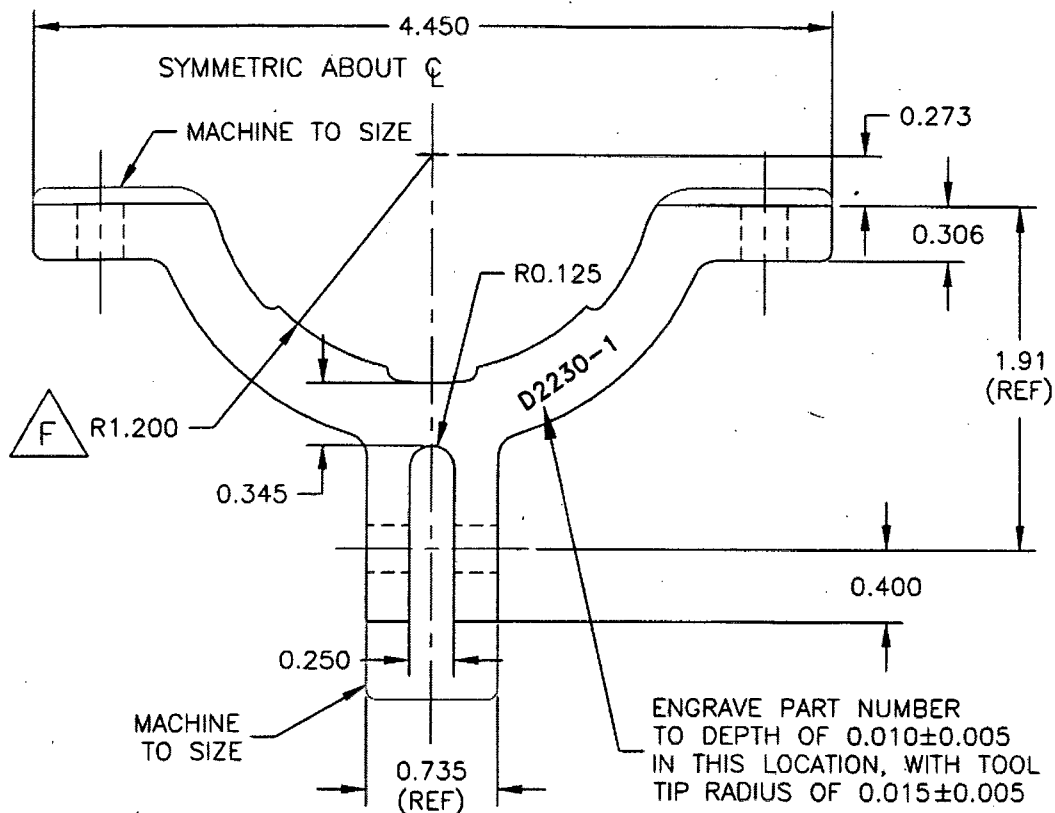
**NOTE:** Date & initial all entries





DESIGN	UP	DRAWN BY	UP	DART AEROSPACE LTD	REV. F
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO.	SHEET 1 OF 2
				D2230	
DATE	99.12.13			TITLE	SCALE
				MOUNTING LUG	1:1
C	94.03.30	RE-DESIGN			
D	95.01.04	RE-DESIGN			
E	95.01.04	RE-DESIGN			
F	99.12.13	REDESIGN; R1.200 WAS R1.100			

RELEASED  
99.12.21 05



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

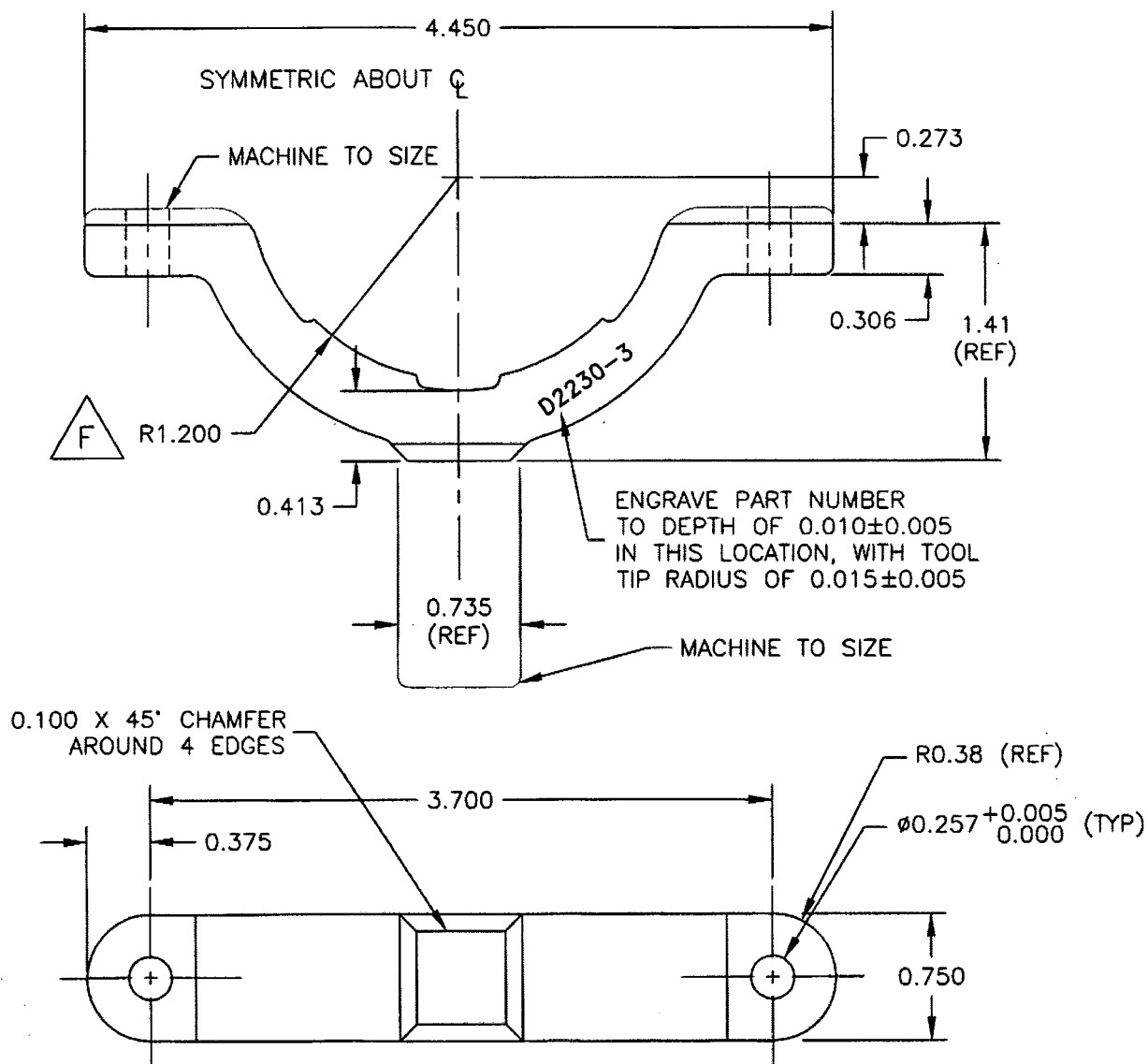
SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 4822



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED  
79.12.21 DS



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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